

Work Order ID 151974

Friday, October 14, 2016 1:56:23 PM

151974

Page 1

Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Forward Wearplate
Start Date: 10/3/2016 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 10/14/2016 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: **DAS 21** Date: **OCT 17 2016** Tooling: Date: Run Start ***NR1***
QC: **9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	C								
100	FLOW WATER JET	0.01							
100									
Waterjet	Memo	0.12							
FLOW CNC Waterjet	1-Cut as per Dwg D3319 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.03							
Quality Control									

8**2-16/10/22****8****2-16/10/22****8****DAS 38 9-89****OCT 25 2016**

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Brake NC Brake NC	NC BRAKE Memo 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: <u>C</u> 2- Form flat on press using DT8776 block	0.01 0.07			DAS 30 9-89	8			OCT 27 2016
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.03				8			DAS 38 9-89 OCT 27 2016
160 *160* Large Fab Large Fab	Weld per dwg A/R Hardcoat steel Batch: <u>M135425</u> Large Fab Memo 1- Layout weld location as per Dwg D3319 using jig D3319-1T3 2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: <u>C</u> Qty Part Number Description Batch A/R N/A 228/7560 Hardcoat Rod <u>M135425</u>	0.00 0.25				8			DYC/EL 16/10/31

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				(8)			DAS 33 9-88 OCT 31 2016
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.03				(8)			DAS 33 9-88 OCT 31 2016
190 *190* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M 131858</i> Memo START TIME: <i>2:20</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>2:50</i>	0.00 0.00				8			<i>10-11-01</i>

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Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				8			DAS 38 9-89 NOV 03 2016
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: 8603 Packaging Memo Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: 8603	0.00 0.01				8x			DAS 26 9-89 NOV 14 2016
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.13							DAS 21 9-89 NOV 14 2016

DAS
21
9-89

NOV 14 2016

Picklist Print

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Work Order ID: 151974

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Parent Item: D3319-1

D3319-1

Parent Item Name: Forward Wearplate

Start Date: 10/3/2016

Required Date: 10/14/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B05.10.14Added step 9, dwg rev B KJ/EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased		No		100	sf	41.0042	0.628	5.288421			

M1010S18GA

1010/1025 SHEET .048

on 10/10/22

Location

Loc Qty

Loc Code

MAT019

41.004152

124428

3

m130454

0.3542

m132886

10.45

m134083

10.7

m134982

6.5

m135612

10

5

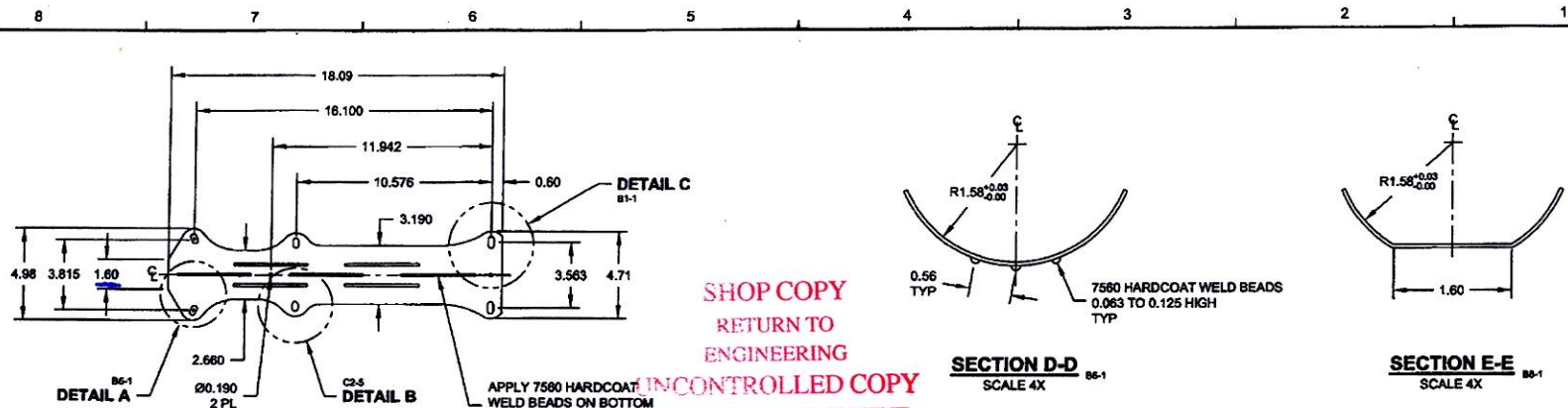
DART AEROSPACE LTD		Work Order:	151974
Description: Wearplate		Part Number:	D3319-1
Inspection Dwg: D3319 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

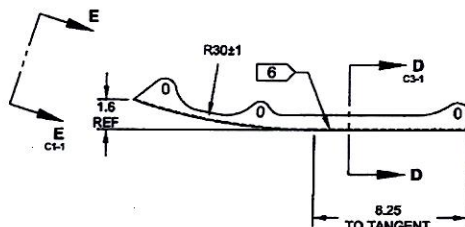
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.98	+/-0.030	4.982	1		V:02-02	
1.60	+/-0.030	1.60	1		V:02-01	
2.660	+/-0.010	2.666	1		Tape	
3.190	+/-0.010	3.196	1			
3.563	+/-0.010	3.561	1			
4.71	+/-0.030	4.711	1			
0.60	+/-0.030	0.602	1			
10.576	+/-0.010	10.575	1			
11.942	+/-0.010	11.945	1			
18.09	+/-0.030	18.09	1			
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	Ø.315x.542	1			
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	Ø.315x.673	1			
Ø0.190	+0.005/-0.001	Ø.194	1			
3.815	+/-0.010	3.816	1			
16.100	+/-0.010	16.100	1			

Measured by:		Audited by:	DAS 38 9-88	Preliminary Approval:	
Date:	16/10/22	Date:	OCT 25 2016	Date:	

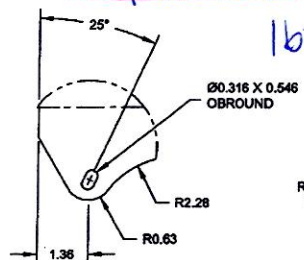
Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	



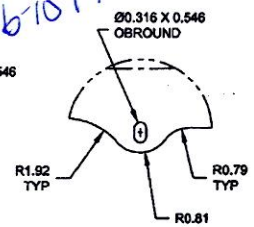
D3319-1F FLAT PATTERN



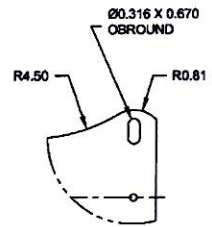
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



DETAIL A
SCALE 4X



DETAIL B
SCALE 4X



DETAIL C
SCALE 4X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151974 M/S
161017

D3319-1 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-03-16
PER ECN 12-946 R12-3.16

C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT. MOST HOLE ON -3/-5/-7 (REF DETAIL G). SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/-5/-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3319	SHEET 1 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		WEARPLATE	NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.03.13		

DESIGN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.03.13		
WEARPLATE			
TITLE			
SCALE			
REV. C			
DRAWING NO.	D3319		
HAWKESBURY, ONTARIO, CANADA			
DART AEROSPACE LTD			

RELEASED
2012 JUL 16
12.03.13

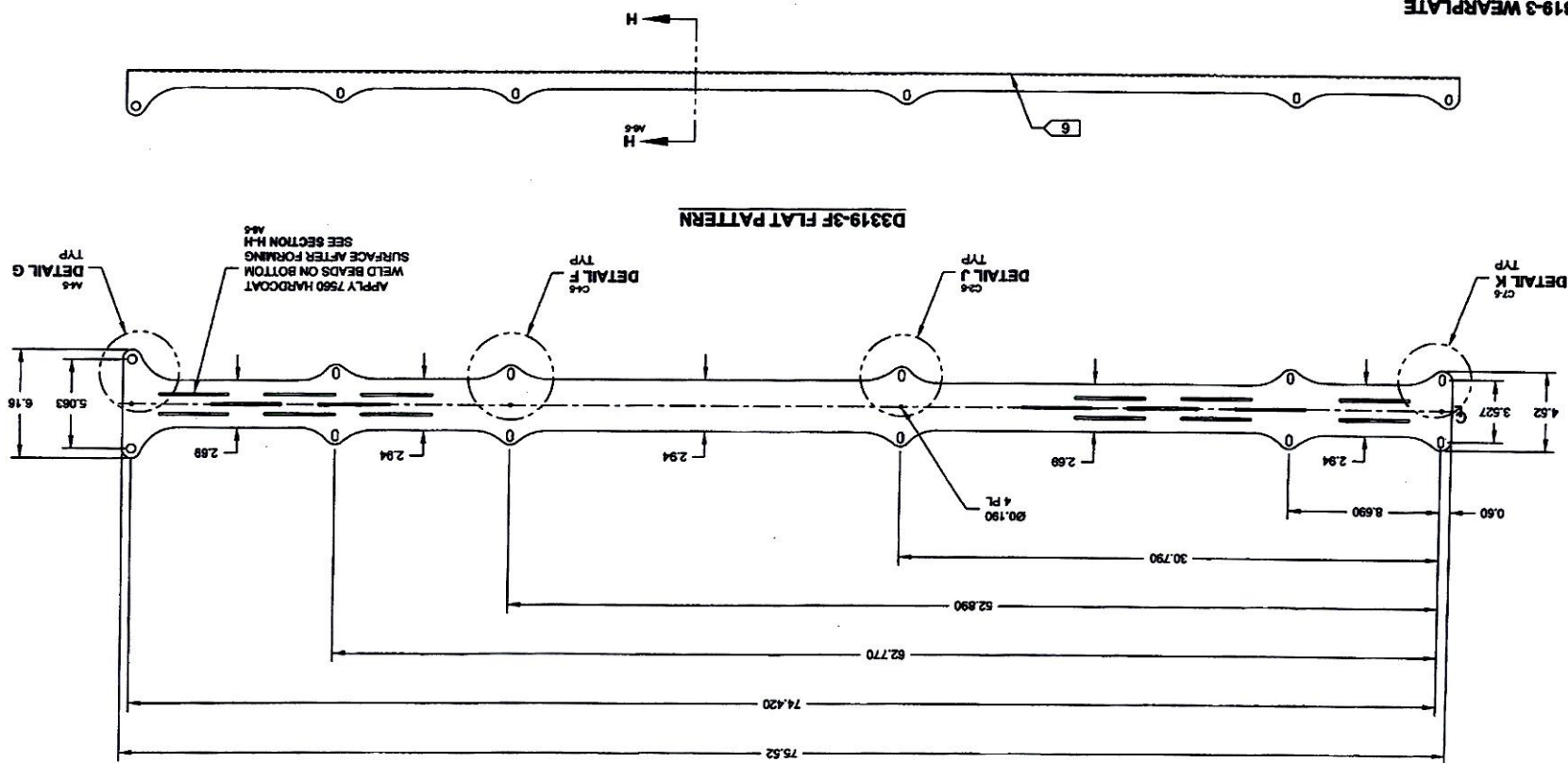
- NOTES:
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A36/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF. A.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCGA-PDA, DART AEROSPACE LTD., PN D3319-3 BN BX000X"
 - 7) WEIGHT: 3.25 lbs APPROX
 - 8) SYMMETRY: ABOUT CENTERLINE

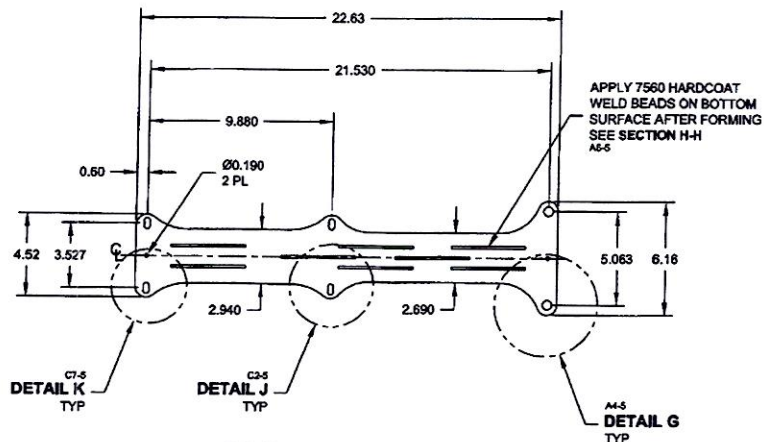
D3319-3 WEARPLATE

D3319-3 BENDING DETAIL

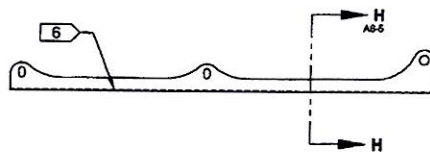
MAKE FROM D3319-3F

D3319-3F FLAT PATTERN

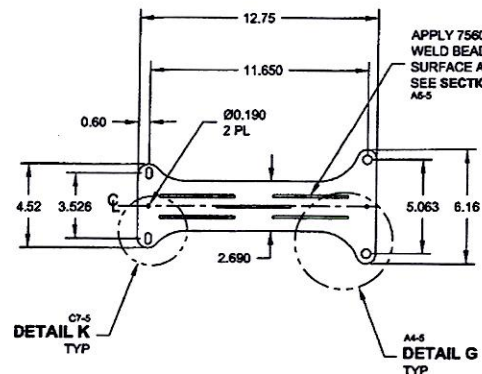




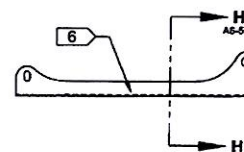
D3319-5F FLAT PATTERN



D3319-5 BENDING DETAIL
MAKE FROM D3319-5F



D3319-7F FLAT PATTERN



D3319-7 BENDING DETAIL
MAKE FROM D3319-7F

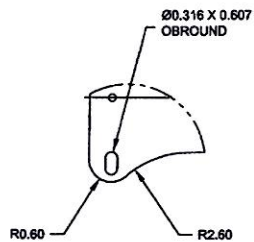
D3319-5-7 WEARPLATE

NOTES:

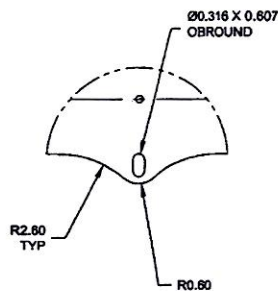
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-02-16
912-0316

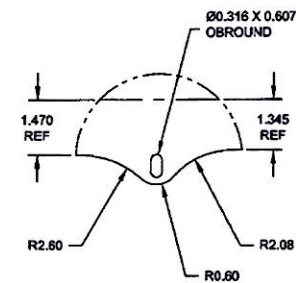
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3319	SHEET 3 OF 4
MFG. APPR.		TITLE	SCALE
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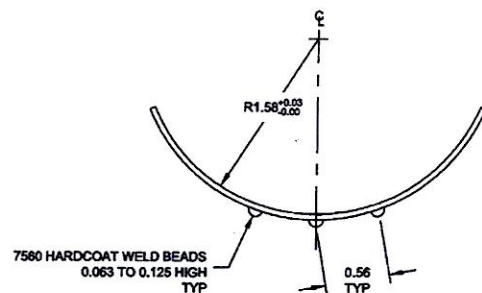
DETAIL K
SCALE 2X
B4-2
C4-3
C6-3



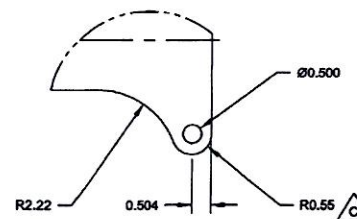
DETAIL F
SCALE 2X
B3-2



DETAIL J
SCALE 2X
B6-2
C7-3



SECTION H-H
SCALE 4X
B4-2
B3-3
B6-3



DETAIL G
SCALE 2X
B6-2
C2-3
C6-3

RELEASED
2012-02-16
4.2.03.16

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3319	SHEET 4 OF 4
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